

## WHAT IS CLAIMED:

1. A composition comprising:  
  
a rubber-modified polymer formed by the polymerization of a monovinylaromatic monomer in the presence of a rubber selected from the group consisting of natural rubbers, polybutadienes, polyisoprenes, and copolymers of butadienes or isoprene with styrene; and  
  
at least one ESCR enhancing additive chosen from the group consisting of polyisobutylene, polymerized alpha-olefins of at least 10 carbons, atactic polypropylene, or polyolefin copolymers.
2. The composition of claim 1 wherein the ESCR enhancing additive is added to the polymer composition in amounts of from about 0.1 wt% to about 6 wt% of the composition.
3. The composition of claim 1 further comprising mineral oil in amounts of from about 0.1 wt% to about 6 wt% of the composition.
4. The composition of claim 1 wherein the resulting composition has an ESCR value greater than about 75.
5. The composition of claim 1 wherein the rubber is in the range of about 5 to 15 percent by weight.

6. The composition of claim 1 wherein more than one ESCR enhancing additive is present in the amount of about 0.5 to about 3.0 percent by weight each.
7. The composition of claim 1 wherein the ESCR enhancing additive comprises a liquid synthetic hydrocarbon.
8. The composition of claim 1 wherein the ESCR enhancing additive comprises polymerized alpha-olefins of at least 10 carbons having a viscosity range of about 200 – 1000 cst @ 99 °C.
9. The composition of claim 1 wherein the ESCR enhancing additive comprises polymerized alpha-olefins of at least 10 carbons having a density range of about 0.80 – 0.95 g/cc @ 25 °C.
10. The composition of claim 1 wherein the ESCR enhancing additive comprises VYBAR 825.
11. The composition of claim 1 wherein the monovinylaromatic monomer is selected from the group consisting of styrene, alphamethyl styrene and ring-substituted styrenes.
12. The composition of claim 1 wherein the monovinylaromatic monomer comprises styrene and the additives are added to the compound prior to or during polymerization.

13. The composition of claim 1 wherein the ESCR enhancing additive comprises atactic polypropylene and the final composition has an ESCR of at least 75.
14. The composition of claim 1 wherein the ESCR enhancing additive comprises copolymers of ethylene and propylene that are amorphous ethylene-propylene copolymers.
15. The composition of claim 14 wherein the molar heat of fusion for the copolymer is less than about 190 J/g.
16. The composition of claim 1 further comprising a chain transfer agent.
17. Molded thermoplastic article made from the polymeric composition of claim 1.
18. The article of claim 17, wherein the article comprises a refrigerator liner.
19. The article of claim 17, wherein the article comprises a molded thermoplastic food product container.
20. A process for producing a composition, comprising:  
polymerizing a mixture of a monovinylaromatic monomer and rubber, the monovinylaromatic monomer being selected from the group consisting of styrene, alphamethyl styrene and ring-substituted styrenes, and the rubber being selected from the group consisting of polybutadiene, polyisoprene,

copolymers of butadiene or isoprene with styrene, and natural rubbers; and adding to the mixture of monomer and rubber, prior to or during the polymerizing process, at least one ESCR enhancing additive chosen from the group consisting of polyisobutylene, polymerized alpha-olefins of at least 10 carbons, atactic polypropylene, or a polyolefin copolymer.

21. The process of claim 20 further comprising adding mineral oil to the mixture in amounts of from about 0.1 wt% to about 6 wt% of the composition.
22. The process of claim 20 wherein the ESCR enhancing additive is added to the mixture in amounts of from about 0.1 wt% to about 6 wt% of the composition.
23. The process of claim 20 wherein the resulting composition has an ESCR value greater than about 75.
24. The process of claim 20 wherein the rubber is in the range of about 5 to 15 percent by weight.
25. The process of claim 20 further comprising adding a chain transfer agent to the mixture.
26. A food service article made from a composition comprising:  
a rubber-modified polymer formed by the polymerization of a monovinylaromatic monomer in the presence of a rubber; and

at least one ESCR enhancing additive chosen from the group consisting of polyisobutylene, polymerized alpha-olefins of at least 10 carbons, atactic polypropylene, or a polyolefin copolymer.

27. The food service article of claim 26, wherein the composition has an ESCR value of at least 75.
28. The food service article of claim 26, wherein the article comprises a refrigerator liner.
29. The food service article of claim 26, wherein the article comprises a molded thermoplastic food product container.